

Date: Friday, 01/02/2008 8:56:55 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FORWARD DOUBLER
 Job Number : 37136
 Estimate Number : 13150
 P.O. Number :
 This Issue : 01/02/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL /MED FAB
 Previous Run :
 Written By : U
 Checked & Approved By :
 Comment : Est Rev:A 08-01-30 new issue DD verified by:

Part Number : D37021
 Drawing Number : D3702 *OR prototype*
 Project Number : N/A
 Drawing Revision : U/R
 Material :
 Due Date : 08/02/2008 Qty: 2 Um: Each

PROTOTYPE

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S080 6061-T6 .080 Sheet



Comment: Qty.: 0.5837 sf(s)/Unit Total: 1.1674 sf(s)
 6061T6 aluminium sheet .080" thick
 (M6061T6S080)
 Batch: 106320 IB 8-2-1

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3702
 Dwg Rev: U/R
 Prog Rev: U/R

IB 8-2-1



see prototype request form

2- Deburr if necessary

IB 8-2-1

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-2-1

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr if necessary

IB 080220

Date: Friday, 01/02/2008 8:56:55 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FORWARD DOUBLER

Job Number: 37136

Part Number: D37021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING
APPROVAL



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Bog-02-20

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Don Stow



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Bog-02-20

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

H 08105/20

Job Completion



FOR ENGINEERING USE ONLY

MF

08-05-16

POSITIVE RECALL

FOR ENGINEERING USE ONLY

EFFECTIVE 02/01/01

RELEASED DATE

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

CERTIFICATE OF CONFORMITY
REQUIRED

Product #: D412-761

Job #: 00224A

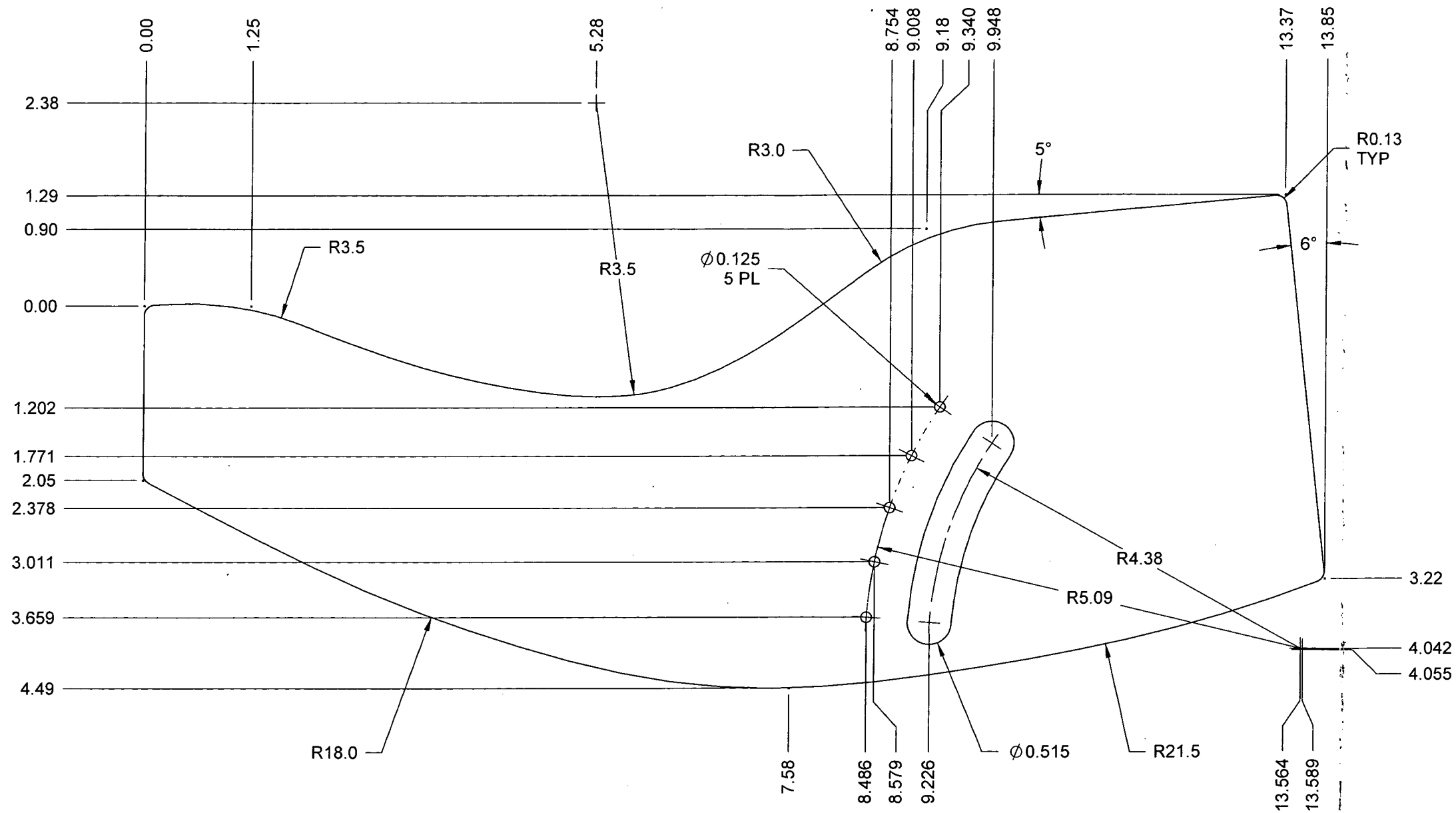
Date: 08.01.31

Product Name: VERTICAL REFERENCE DOOR

Requested By: MB

Design Manager Approval: [Signature]

| Quantity | Part Number | Description | Drawing Date | Material Cert Req'd? | Due Date | Comments | Date Completed |
|----------|-------------|------------------------------|--------------|----------------------|----------|--|----------------|
| 2 | D3700-1 | INBOARD WINDOW DOUBLER | 08.01.29 | YES | ASAP | SEE BELOW | |
| 2 | D3700-3 | OUTBOARD WINDOW DOUBLER | 08.01.29 | YES | ASAP | SEE BELOW | |
| 2 | D3701-1F | (FLOOR DOUBLER) FLAT PATTERN | 08.01.29 | YES | ASAP | SEE BELOW | |
| 2 | D3702-1 | FORWARD DOUBLER | 08.01.30 | YES | ASAP | MAKE ONE WITH HOLES/SLOT + ONE WITHOUT HOLES/SLOT + SEE BELOW. | |
| 2 | D3703-1 | AFT DOUBLER | 08.01.30 | YES | ASAP | SEE BELOW | |
| | | | | | | | |
| | | | | | | | |
| | | | | | | | |
| | | | | | | | |
| | | | | | | HAND ALL W/Os AND PARTS TO DAN STOW | |
| | | | | | | | |

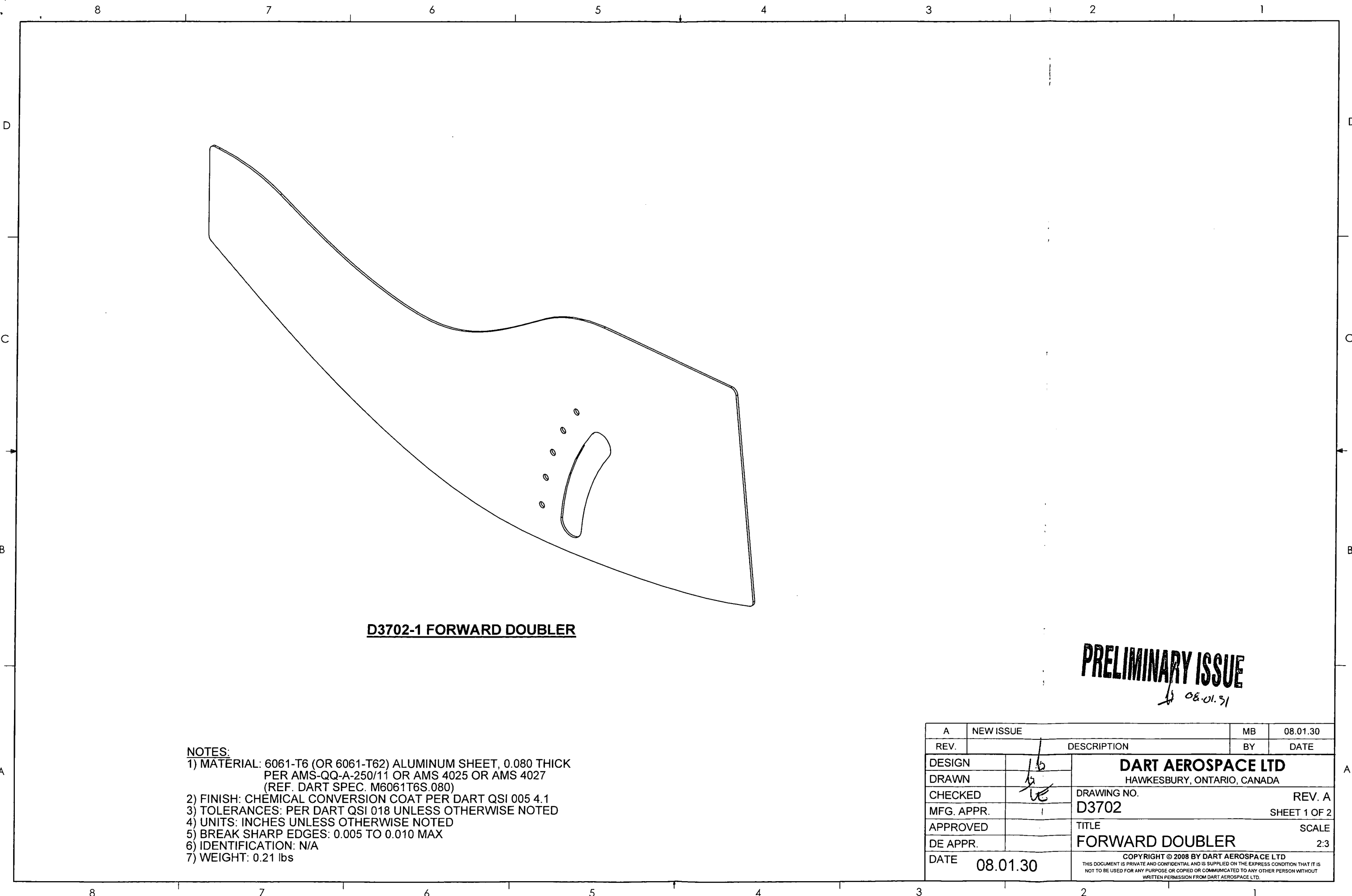


D3702-1 FORWARD DOUBLER

PRELIMINARY ISSUE

06.01.31

| | | | |
|------------|----------|--|--------------|
| DESIGN | | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | | | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3702 | SHEET 2 OF 2 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | FORWARD DOUBLER | 2:3 |
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NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.21 lbs

PRELIMINARY ISSUE
08.01.31

| | | | |
|------------|-------------|--|--------------|
| A | NEW ISSUE | MB | 08.01.30 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | 16 | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | 16 | | |
| CHECKED | 16 | DRAWING NO. | REV. A |
| MFG. APPR. | 1 | D3702 | SHEET 1 OF 2 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | FORWARD DOUBLER | 2:3 |
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